

19-7801



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18586-1
Job Sheet 200080



Part No: RBT18586-1

Job Qty: 16 pcs

DAS
21
9-00

Part Name: Dummy filter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/6/19

Job Tracking No:

Due Date: 11/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18586 Rev. 2 IPP Rev. A 18.08.17 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
110	SL-154 - 1	16 pcs	11/7/19	11/7/19	1.00	4.00	SL-154 - 1	[Signature] 11/14/19
120	QC 2	16 pcs	11/7/19	11/7/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	[Signature] 11/14/19
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	



Container No: S229710



Part: RBT18586-1

Job No: 200080

Serial No/Batch: S229710

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 11/06/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

P.T.O.

				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	16 pcs	11/7/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
150	Outsource - 4 - Anodize	16 pcs	11/7/19		ATG001 VC - GR0002 11/2019-11-07
160	Packaging 2-1 - Receive - B4B	16 pcs	11/7/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B

Plex 9/6/19 12:46 PM Dart.lajeunesse.marie

				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170 QC 6	16 pcs	11/7/19	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	NOV 13 2019 68
				QC 6 - 61	9-89
				QC 6 - 40	
				QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	16 pcs	11/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLL
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
190 QC 21 - SA	16 pcs	11/7/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-89
				QC 21 - SA - 53	NOV 14 2019
Part Op 110 - MORI SL-154 LATHE - 1-Machine as per DWG. FC364 FOLIO REV: <u>AA</u> DWG REV: <u>2</u> 2- Descriptions: Deburr 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 150 - -Issue P/O to GROUPE ALTECH PO: <u>45030</u> -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL - Certificate of Conformity is required 160 - Receive & Inspect for Damage & Mat'l Certs 170 - QC6- All purchased or subcontracted products 180 - Identify as per dwg & Stock Location: _____ 190 - QC21- Final Inspection - Work Order Release					

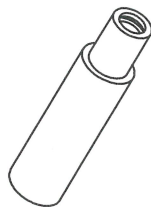
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.625	6061-T6 Round Bar .625"	3.4400 ft (.215 ea)	110-SL-154 - 1	5226335 5150604
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	M6061T6R0.625	3	13	0
Part Specifications				
Specifications could not be found.				

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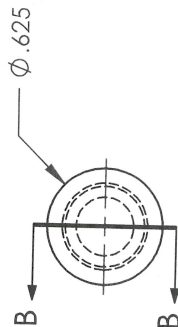
This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced in any form without the prior written permission of Dart Aerospace Eugene, OR.

REV		ECR	REVISIONS		DATE	INITIAL	APPROVED
2	16-0284	-1	ADDED ENGRAVE T/N, S/N, "MADE IN USA" NOTE.		1/12/2017	RJC	

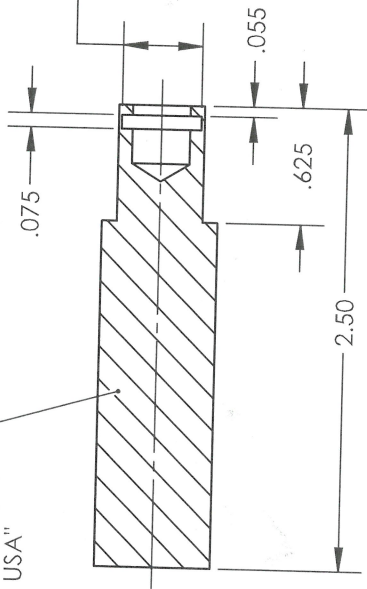
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 200080 MJS
14-09-06



ENGRAVE T/N, S/N,
"MADE IN USA"



Ø .625



Ø .430

Ø .463

Ø .313
▽ .32

SECTION B-B

SEE ATTACHED DEVIATION



TITLE

DUMMY FILTER ELEMENT

DWG NO.

RBT18586-1

REV

2

MAT'L ALUMINUM

HEAT TREAT

FINISH CLEAR ANODIZE

SPEC MIL-A-8625F, TYPE II, CLASS I

DRAWN BY: CLOUGH

CHECKED:

OPPS APPR:

QA APPR:

APPROVED:

SCALE 1:1

DATE

6/9/2015

SHEET 2 OF 2

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS ARE 16

XXX ± .005

XX ± .01

X ± .1

ANGLES ± 5°

SURFACES = 125/

1. BREAK ALL SHARP EDGES

2. DIMENSIONAL LIMITS APPLY

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

USED ON MODEL

BELL 407

(-1)

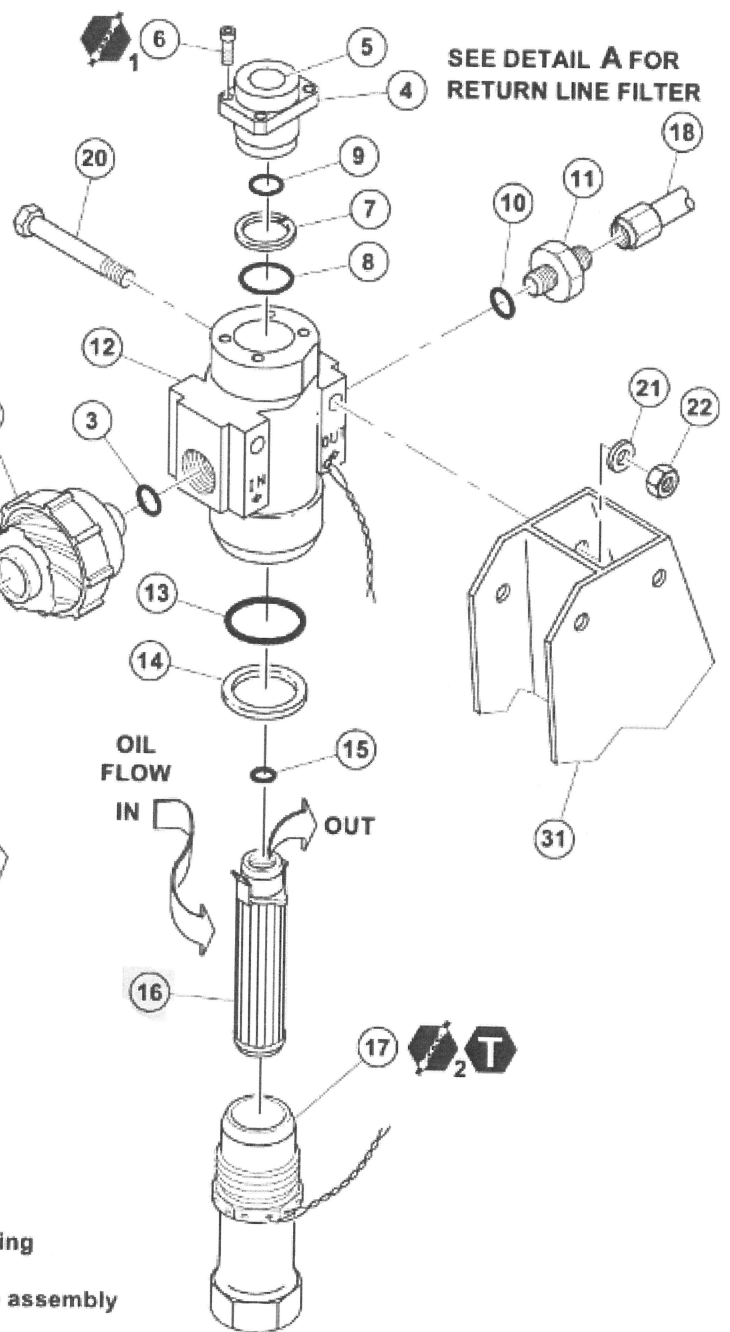
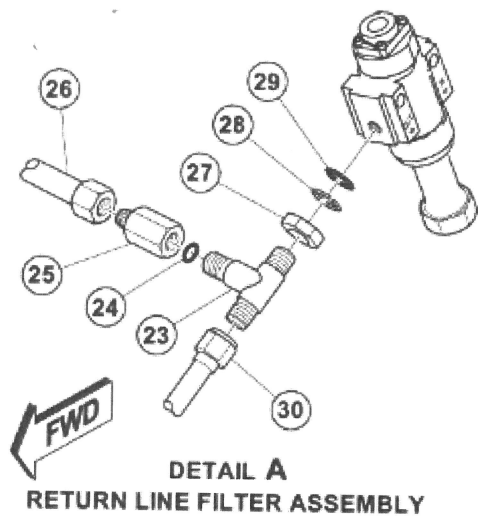
DUMMY FILTER

Ketan Tailor

From: Ross Black
Sent: November-06-19 9:48 AM
To: Ketan Tailor
Subject: RBT18586

Hey Ketan,

RBT18586 replaces #16 (fuel filter) in the below assembly. This is done to simulate a clogged filter, to test the fuel bypass function.



- | | |
|------------------------------------|------------------------------|
| 1. Coupling half | 19. Hose assembly |
| 2. Coupling half | 20. Bolt |
| 3. Preformed packing | 21. Washer |
| 4. Differential pressure indicator | 22. Nut |
| 5. Red indicator button | 23. Reducer tee |
| 6. Bolt | 24. Preformed packing |
| 7. Retainer | 25. Check valve |
| 8. Preformed packing | 26. Case drain hose assembly |
| 9. Preformed packing | 27. Nut |
| 10. Preformed packing | 28. Retainer |
| 11. Union | 29. Preformed packing |
| 12. Filter body | 30. Hydraulic system |

FILTER ASSEMBLY
(TYPICAL)

Ross Black
Product Manager

DART AEROSPACE
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M 1 613 402-1515
www.dartaerospace.com



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Tel (613) 632-5200

PURCHASE ORDER **POHB045030**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045030

PO Date: 11/7/19

Due Date: 11/15/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-11

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200080	RBT18586-1	RBT18586 Rev 2	Dummy filter -Issue P/O to GROUPE ALTECH PO: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL - Certificate of Conformity is required	Firmed - <i>X32</i>		11/15/19	32 pcs	0 pcs	32 pcs	\$3.1578/pcs	\$101.05
2	199902	RBW6405G12031-3G-3	RBW6405G12031-3G Rev 3	Tube -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed - <i>X6</i>		11/15/19	6 pcs	0 pcs	6 pcs	\$3.1578/pcs	\$18.95
Grand Total:												\$120.00

Guerin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045030



Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/11/19 8:56 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(023955-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip

023955 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courrier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
12-Nov-2019		Jigar Patel				POHB045030			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT18586-1 Rev.2	RBT18586 01-ANO-CLEAR [ANODIZE CLEAR] AS PER IAW MIL -A-8625F TYPE - 2, CLASS - 1 WATER SEALANT		ANODIZE CH	32 —	32	0	0	0 
2	RBW6405G12031-3G-3 Rev.3	RBW6405G12031-3G 01-ANO-CLEAR [ANODIZE CLEAR] AS PER IAW MIL -A-8625F TYPE - 2, CLASS - 1 WATER SEALANT		ANODIZE CH	6 —	6	0	0	0 

RECEIVED

NOV 12 2019

DART AEROSPACE LTD.

RECEIVED
 NOV 12 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

Entered:

Date:

19/11/19

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

19-7801

Route update only



Job: <u>20080</u> Part No. <u>RBT18586 REV. 2</u>		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Engineering ☐ Machining ☒ Water Jet ☐ Large Fab ☐ Supplier ☐ Quality ☐	
Date: <u>19/11/19</u>	Sequence #: <u>110</u>	QTY Affected: <u>32</u>	
Description Work Order Deviation		Disposition	
RBT18586-1: -DIMENSION 0.430 CHANGE FOR 0.430 +0 / -0.005" -DIMENSION 0.463 CHANGE FOR 0.463 +0.005" / -0 -DIMENSION 0.313 CHANGE FOR 0.313 +0 / -0.005" -ENGRAVING "MADE IN USA" AND S/N REMOVED PER VM		This deviation is acceptable. The fit, form and function of the part will be as originally intended.	
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details:	
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	
		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☒ Finish ☐ Part Lost/Missing ☐ Misread ☐	

MRB (QS1042)

M Lee

AUGUST 17, 2018

Completed By

19/11/29

Lead hand / Supervisor

19/11/29

QC / QA Coordinator

19.11.29